

Work Order ID 68267



Page 1

Monday, April 11, 2011 10:37:22 AM

Item ID:	D4149-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Eyebolt Stud					
Start Date:	4/11/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	4-11-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4149	C								

100		0.00							
Doosan									
Doosan Lathe									

Memo
turn as per dwg and folio FA950
DWG REV:
FOLIO REV:

DEBURR

110		0.00							
QC									
Quality Control									

Memo
 11/4/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00				4	0		
150 Packaging Packaging	Identify as per dwg & Stock Location: 133 Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 MF 11-04-28

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Picklist Print

Monday, April 11, 2011 10:37:29 AM

Page 1

Work Order ID: 68267

Parent Item: D4149-5

Parent Item Name: Eyebolt Stud

Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R1.000

Purchased

No

100

f

12.6070

0.25

1.052632



4/14/27

303 Round Bar 1.00

Location

Loc Qty

Loc Code

MAT028

12.607

116700

12.607

1.05

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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	[Signature]

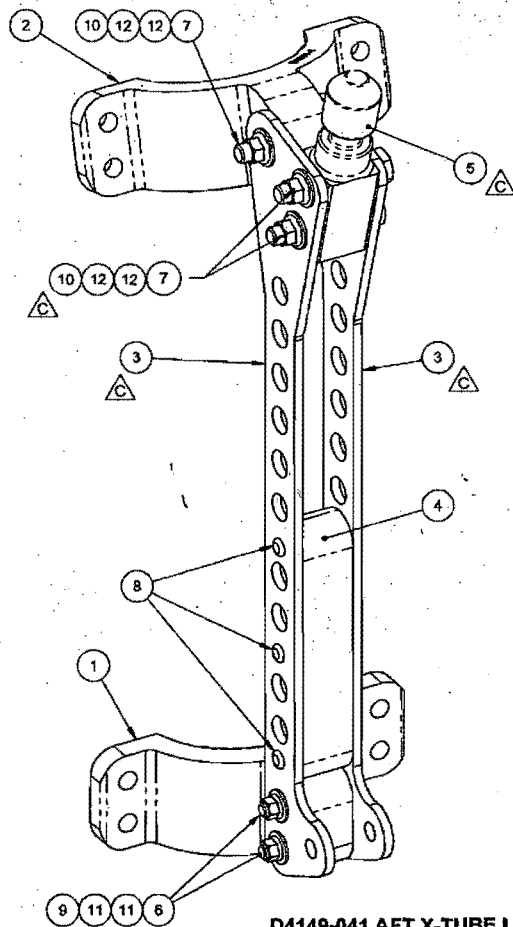
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NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68267

PL11-09-11

RELEASED
2011-02-24

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.1912 PL REPLACES Ø0.1293 PL (ZN D8-3); REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4149 REV. C SHEET 1 OF 5 TITLE AFT X-TUBE LUG ASSY SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED BY THE SERVICE CONTRACT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

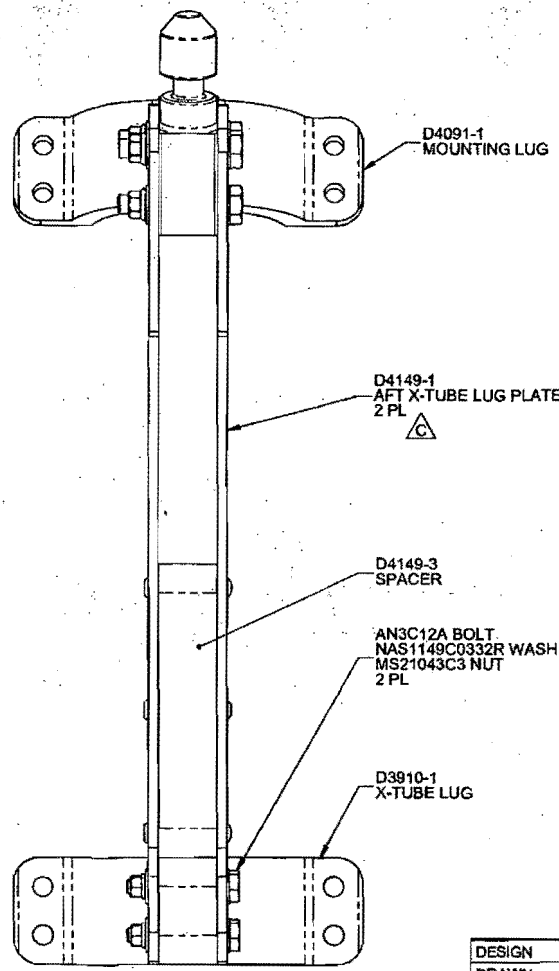
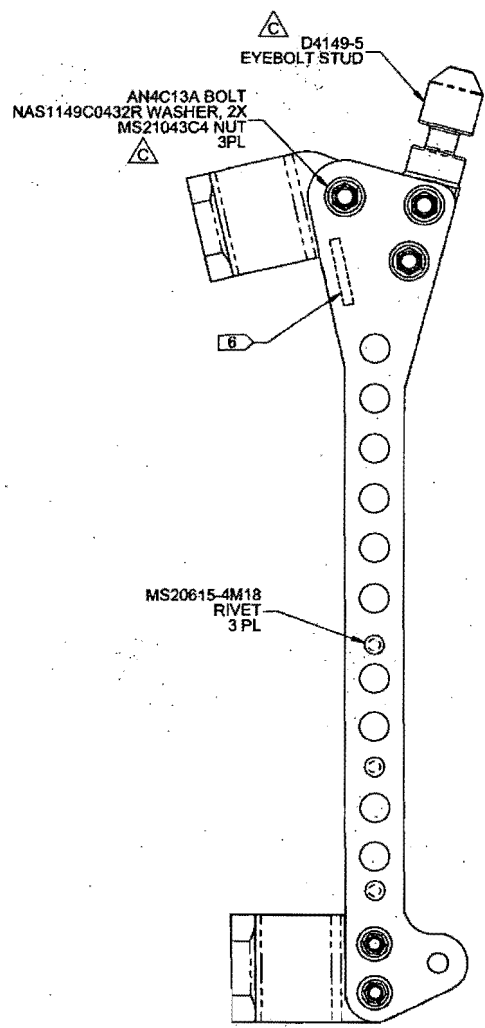
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



W068267

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2011-02-24

D4149-041 AFT X-TUBE LUG ASSY

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MFG. APPR.		D4149	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

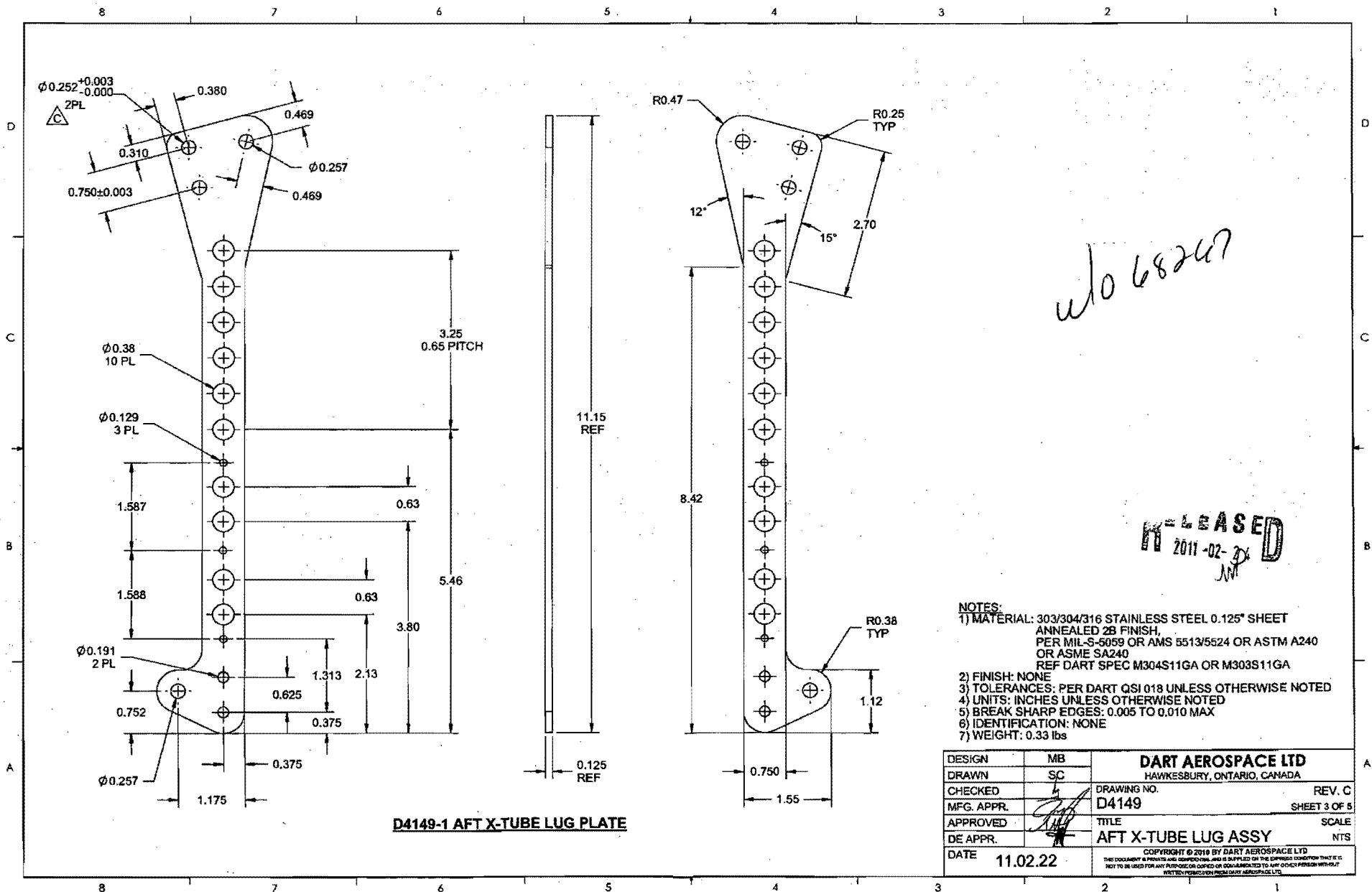
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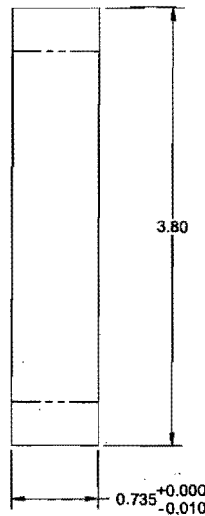
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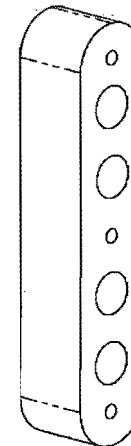
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2011-02-24

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| DRAWN | SC | | DRAWING NO. D4149 | |
| CHECKED | | | REV. C | |
| MFG. APPR. | | | SHEET 4 OF 4 | |
| APPROVED | | | TITLE | |
| DE APPR. | | | AFT X-TUBE LUG ASSY | |
| DATE | 11.02.22 | SCALE
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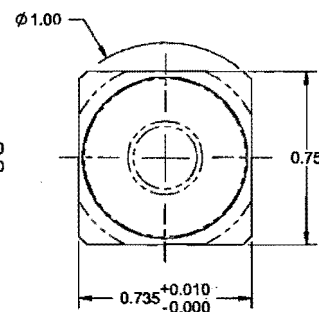
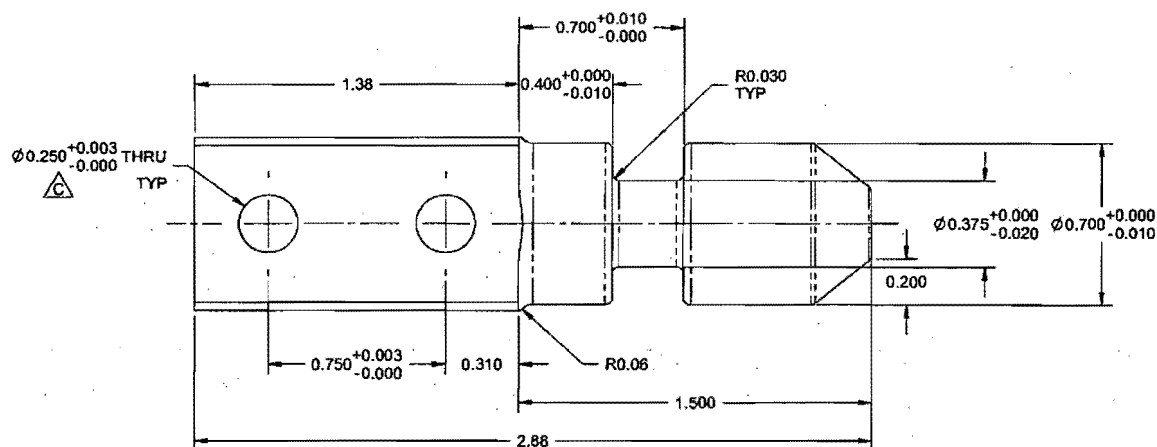
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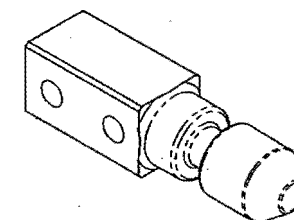
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D4149-5 EYEBOLT STUD



also 68247

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

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H 2011-02-24
W

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